

Work Order ID 81684

81684

Page 1

March-16-12 1:58:56 PM

Item ID: D5957

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle, 205

Start Date: 16/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/16

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5957	Rev B								

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

B.A 12/06/21

8

φ

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per folio D5957, Ensure Batch Number is entered
2-Machine Keyway3-Deburr & Tumble

110

0.00

110

QC1- Inspect dimensions to dimension sheet

B.A 12/06/21

8

φ

QC

Memo

0.00

Quality Control

120

0.00

120

QC8- Inspect parts - second check

amf 12/06/24

8

φ

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81684

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Item ID: D5957 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, 205
 Start Date: 16/03/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 22/03/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00				8			
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				8	2		
140									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11h25	OVEN TEMPERATURE:							
	320°F FINISH TIME: 11h55								
	Memo 222								
150	QC3- Inspect Part Finish	0.00				8	φ		
150									
QC	Memo	0.00							
Quality Control									

8 2 12/05/25.
 8 φ BL 12-5-25.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 3

March-16-12 1:58:56 PM

Item ID: D5957 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, 205
 Start Date: 16/03/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 22/03/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>430</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

12/6/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-16-12 1:59:03 PM

Page 1

Work Order ID: 81684

81684

Parent Item: D5957

D5957

Parent Item Name: Saddle, 205

Start Date: 16/03/2012

Required Date: 22/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:E Re-Format 05-11-29 JLM
IPP Rev:F ecn826 06.12.06 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			110	Each	53.0000	1	6			

D6101-007

**

Saddle Billet

Location	Loc Qty	Loc Code
MAT042	48	
79589	20	
79875	28	
MAT045	5	
70680	3	
76839	2	

83450 X 8 ent 12/06/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	81684
Description: Inner Aft Saddle		Part Number:	D5957
Inspection Dwg: D5957	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		0.319	0.319	0.319	0.319		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		0.319	0.319	0.319	0.319		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.500	0.500	0.500	0.500		
N	1.865	1.885		1.875	1.875	1.875	1.875		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.308	0.313		0.310	0.310	0.310	0.310		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.490	0.490	0.500	0.500		
T	1.625	1.645		1.630	1.630	1.630	1.630		
U	2.000	2.020		2.004	2.004	2.004	2.004		
V	0.023	0.043		0.033	0.033	0.033	0.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>R.A</u>	Audited by: <u>ml</u>
Date: <u>12/06/21</u>	Date: <u>12/06/24</u>

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.09.05	Dimension K revised	KJ/DD	
H	09.07.29	Dimension Q revised	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	81284
Description: Inner Aft Saddle		Part Number:	D5957
Inspection Dwg: D5957	Rev: B	Page 1 of 1	


Inspect dimensions highlighted on inspection sheet drawing and record below:

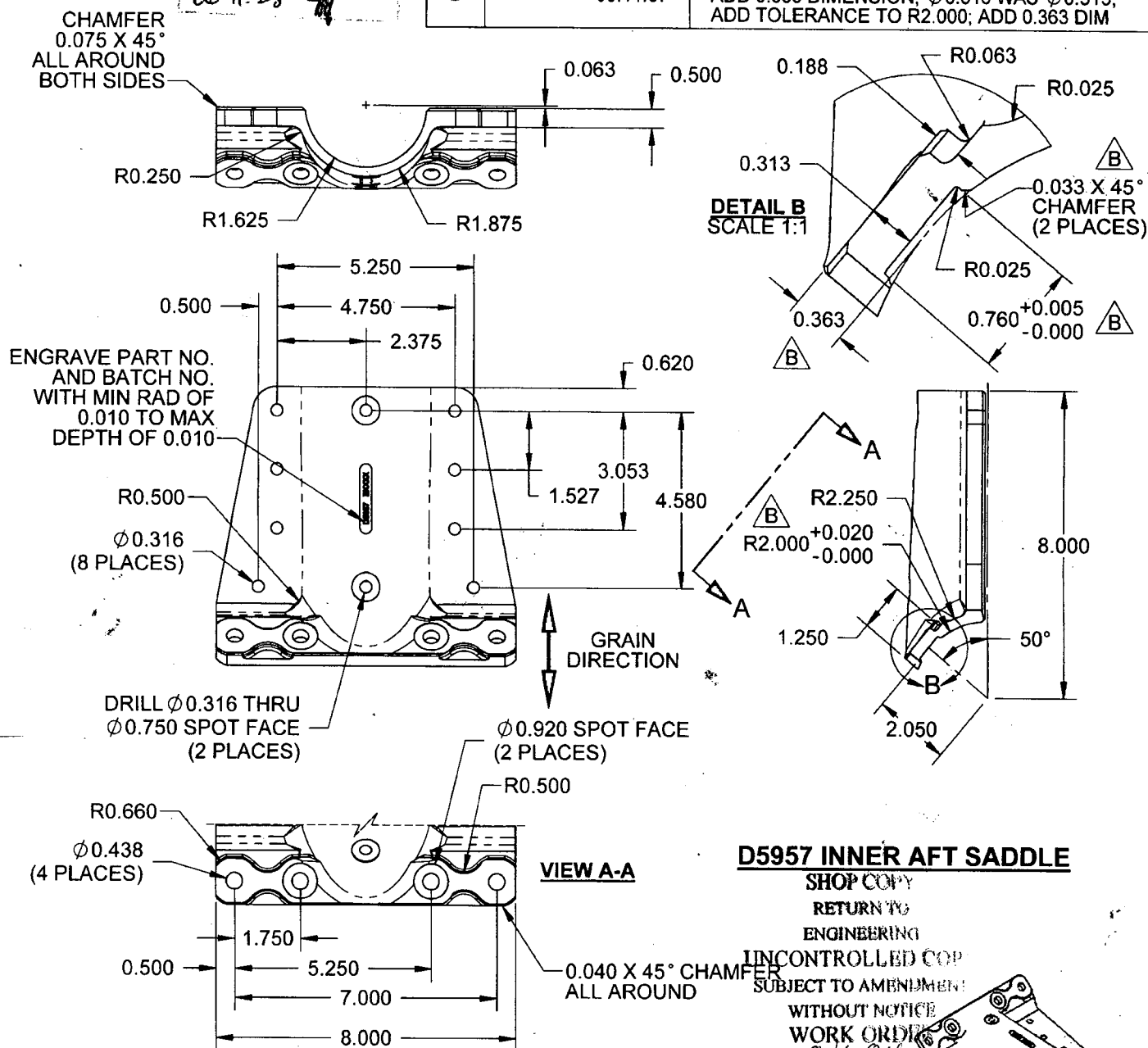
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.440	0.440	0.440	0.440		
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M	0.490	0.510		0.500	0.500	0.500	0.500		
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R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.500	0.500	0.500	0.500		
T	1.625	1.645		1.630	1.630	1.632	1.630		
U	2.000	2.020		2.004	2.004	2.004	2.004		
V	0.023	0.043		0.033	0.033	0.033	0.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: B.A.
Date: 12/06/22

Audited by: am
Date: 12/06/24

Rev	Date	Change	Revised by	Approved
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B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
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F	08.04.21	Dimension E revised	KJ/DD	
G	08.09.05	Dimension K revised	KJ/DD	
H	09.07.29	Dimension Q revised	KJ	

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED 	DRAWING NO. D5957	REV. B SHEET 1 OF 1
DATE 06.11.07		TITLE INNER AFT SADDLE	SCALE 1:4
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; Ø 0.316 WAS Ø 0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

D5957 INNER AFT SADDLE

SHOP COPY

RETURN TO:

ENGINEERING

UNCONTROLLED COP

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 8/684

12/03/14

ISOMETRIC VIEW
SCALE 1:8

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries